

Date: Tuesday, 07/04/2009 10:34:52 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR DOUBLER
<b>Job Number</b> : 47016	
<b>Estimate Number</b> : 12681	
<b>P.O. Number</b> :	<b>Part Number</b> : D3594043
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3594 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46720	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/04/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.04.07</u>	
<b>Comment</b> : Est Rev :A New Issue 07-01-22 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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**Comment:** Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 111003

ml 09.04.08

(10)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

ml 09.04.08

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09.04.08

(10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/04/09

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

ep 09/04/14

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:34:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 47016

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(-3)

Comment: INSPECT WORK TO CURRENT STEP

8 09/04/14

(+10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ell

09-04-11

(x10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/14

(10)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Anchor nuts

BATCH: M111310

EP 09/04/15

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivet

BATCH: M15541

EP 09/04/15

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

EP 09/04/15 (10)

12.0

QC5

INSPECT WORK TO CURRENT STEP



(-3)

Comment: INSPECT WORK TO CURRENT STEP

8 09/04/15

(+10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 234B

EP 9/4/15 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:34:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 47016

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF* 09-04-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

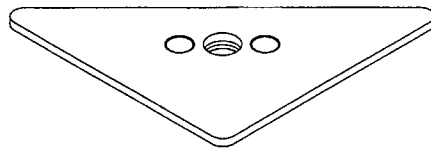
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

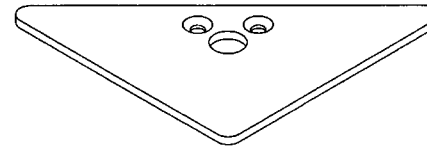
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

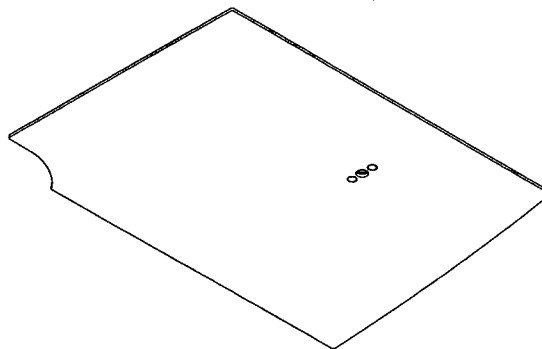




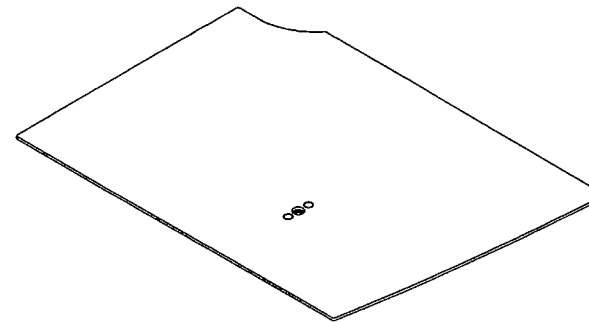
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

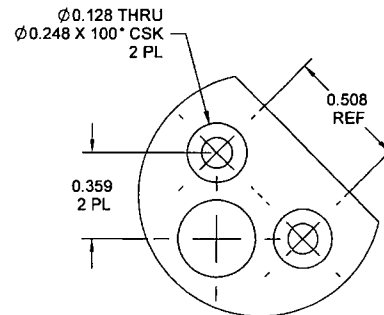
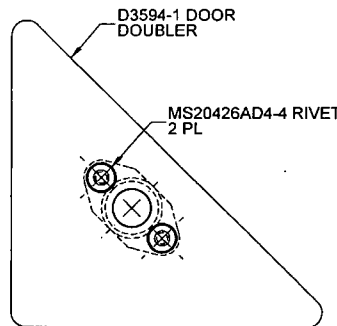
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NO. 1200

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
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DE APPR.		DOUBLER	NTS
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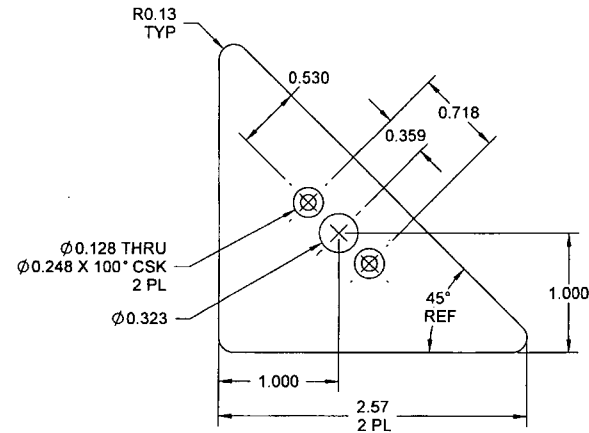
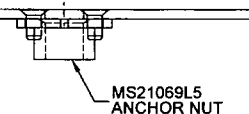


QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK

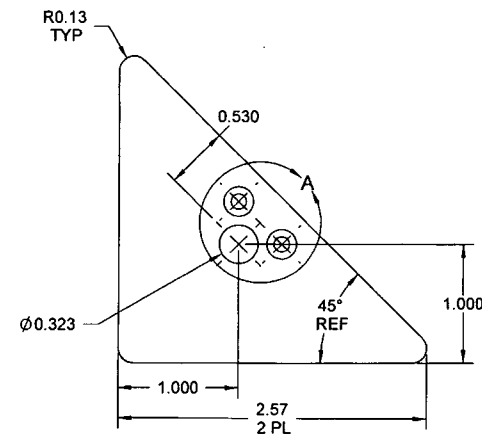


**DETAIL A**  
SCALE 2X

**D3594-041 DOOR DOUBLER ASSEMBLY**



**D3594-1 DOOR DOUBLER**



**D3594-5 DOOR DOUBLER**

**RELEASED**  
158-06-26-14

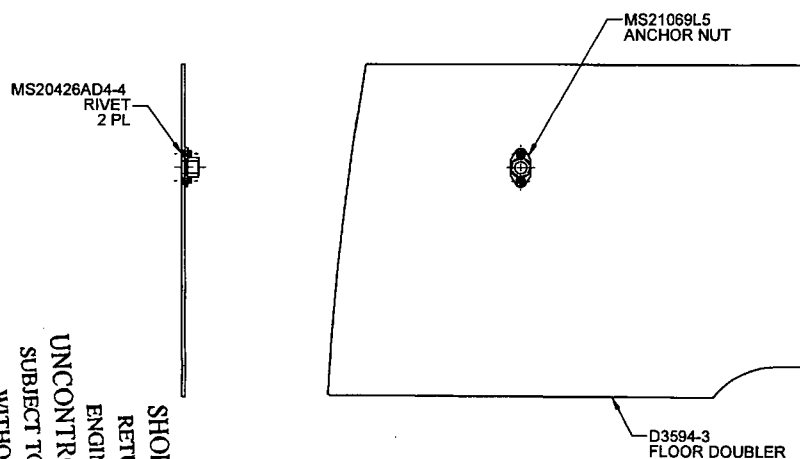
**NOTES:**

- 1) MATERIAL: -1 & -5  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs  
-5: 0.03 lbs

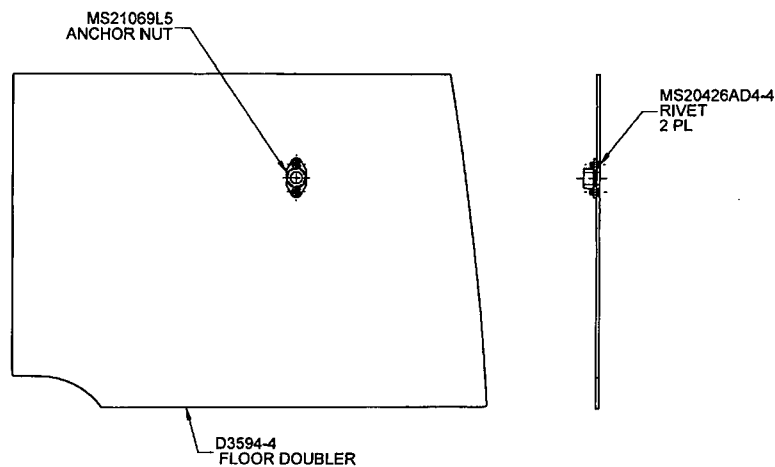
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DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3594</b>	REV. B
MFG. APPR.			SHEET 2 OF 4
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



**D3594-043 FLOOR DOUBLER ASSEMBLY**



**D3594-044 FLOOR DOUBLER ASSEMBLY**

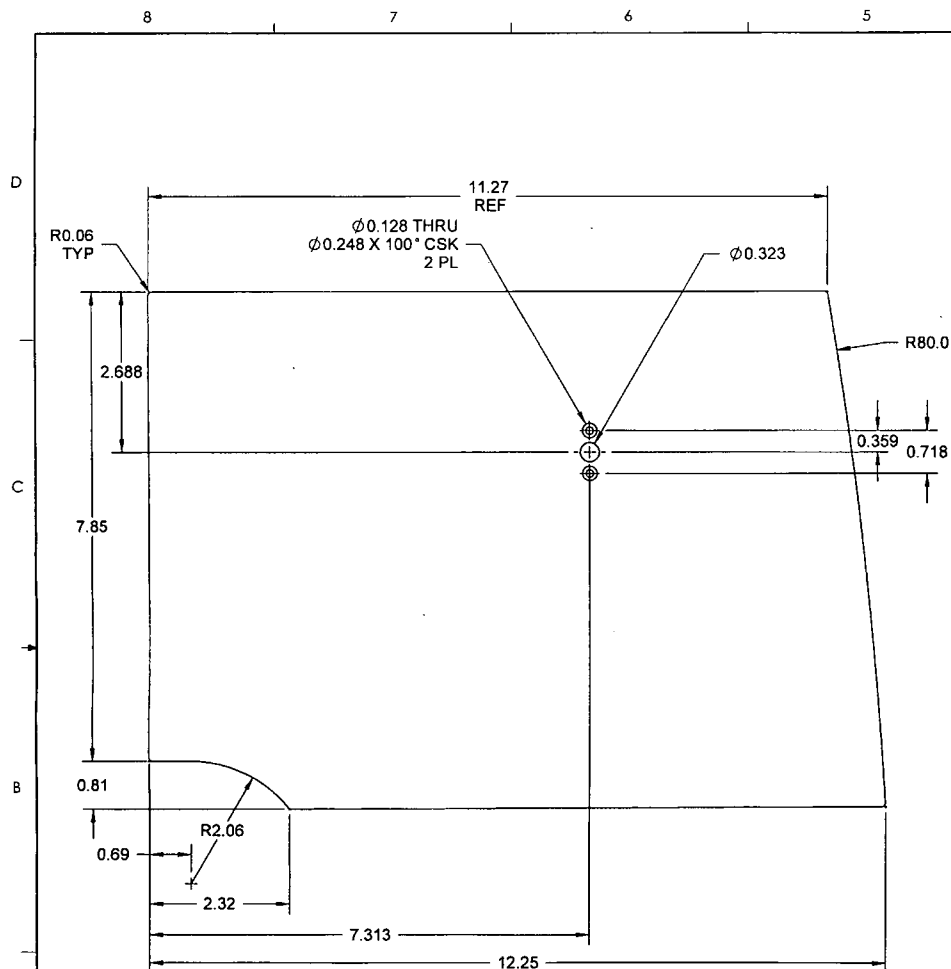
**NOTES:**

- 1) MATERIAL: -3 & -4  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

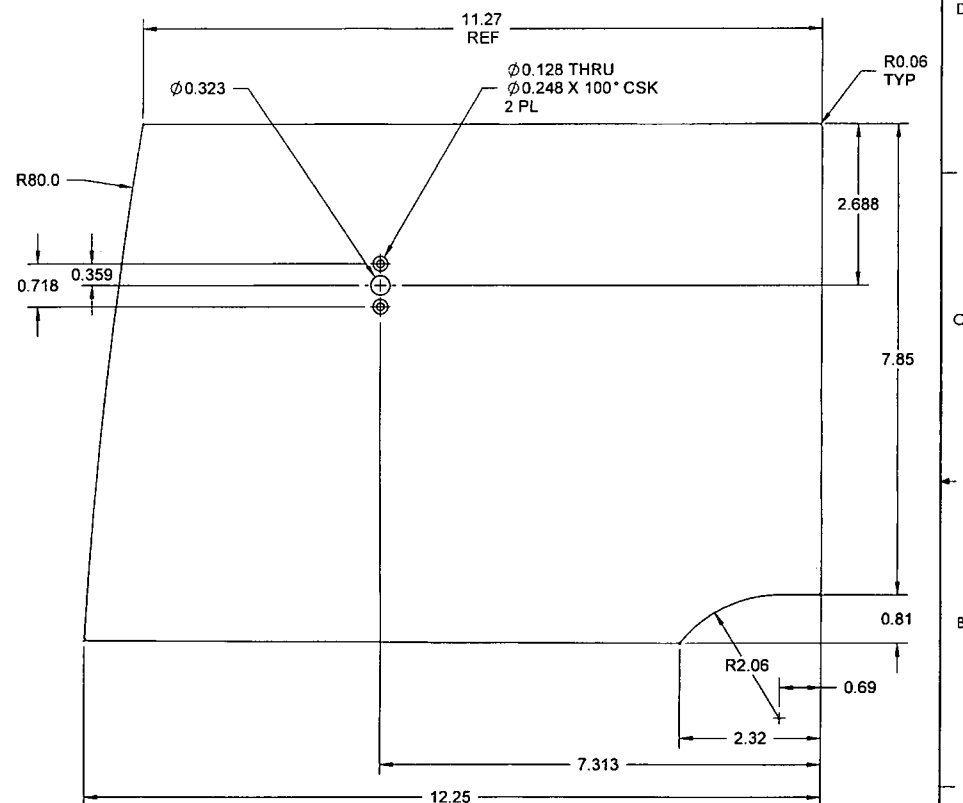
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**D3594-3 FLOOR DOUBLER**



**D3594-4 FLOOR DOUBLER**

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MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOOR DOUBLER ASSEMBLY</b>	SHEET 4 OF 4
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